

Work Order ID 103171

\*103171\*

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June-18-13 11:39:17 AM

Item ID: D4019-041 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Light Lid Short Basket Assembly  
 Start Date: 6/18/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 6/19/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4019	D								

100 Weld per dwg A/R Aluminum rod Batch: 125127 0.00  
 Large Fab

\*100\*

Large Fab

Large Fab

Memo

0.00

1- Assemble ribs , weld as per dwg D4019 using DT9606B. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

\*\*\*\*DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME\*\*\*\*

2- weld hinge, label plate and Mounting plates as per dwg D4019

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

\*110\*

QC

Quality Control

Memo

0.00

①  
 PL 13-6-19

① 13-06-19

DAS  
 09  
 5-85



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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
*120*									
QC	Memo	0.00							DAS 09 2-89
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
*130*									
HandFinish	Memo	0.00							
Hand Finishing	***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***								
140	Weld per dwg A/R Aluminum rod Batch: 125127	0.00							
*140*									
Large Fab	Memo	0.00							
Large Fab	1- weld (4) corners								

N/A WP 13/6/19

CP 13.6.19

1X

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Item ID: D4019-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Light Lid Short Basket Assembly  
 Start Date: 6/18/13 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 6/19/13 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00							DAS 09 9-89
160 <b>*160*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo 1- touch up corner with alodine only 2- Plug holes prior to and mask sides of hinge prior to powdercoat	0.00  0.00							

1ST COAT:  
 START TIME: \_\_\_\_\_  
 OVEN TEMPERATURE: \_\_\_\_\_  
 FINISH TIME: \_\_\_\_\_  
 \*\*\*\*\* 2nd coat if necessary \*\*\*\*\*  
 2ND COAT:  
 START TIME: \_\_\_\_\_  
 OVEN TEMPERATURE: \_\_\_\_\_  
 FINISH TIME: \_\_\_\_\_

*N/A*

FOR ENG

6/13/19

*W*

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC3- Inspect Part Finish <i>QA</i> Memo	0.00 0.00							
180 *180* HandFinish Hand Finishing	Assemble as per dwg <i>N/A</i> Memo Install webbing as per dwg and label	0.00 0.00							
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O <i>ENG PURPOSE ONLY</i> Memo	0.00 0.00							

*104427*

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 Start Date: 6/18/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 6/19/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: _____	0.00							
*200*									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
*210*									
QC	Memo	0.00							
Quality Control									

W13-1143

# Picklist Print

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Work Order ID: 103171

Parent Item: D4019-041

Parent Item Name: Light Lid Short Basket Assembly

Start Date: 6/18/13

Required Date: 6/19/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.12.07 verified by:EC IPP Rev:B as per dwg revA 10.03.15  
verified by:EC IPP Rev:C as per dwg revC DD 10.04.20 verified by:EC IPP Rev:D  
as per dwg revD DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4019-1 Rib		Manufactured	No			100	Each	4.0000	2	2		PC 13.6.19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		4							
				87047		4							
D4019-3 Rib		Manufactured	No			100	Each	21.0000	2	2		PC 13.6.19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		21							
				94113		12							
				94114		9							
D4016-5 Hinge Half, Light Lid		Manufactured	No			100	Each	14.0000	3	3		PC 13.6.19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		12							
				94271		12							
				WA004		2							
				87470		2							
D2957 Mounting Plate		Manufactured	No			100	Each	19.0000	4	4		PC 13.6.19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		19							
				84820		2							
				94166		9							
				94270		8							
D4035-045 Lid Rib Assembly, Fwd (Light)		Manufactured	No			100	Each	0.0000	1	1		PC 13.6.19	

394491 → ①

# Picklist Print

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Work Order ID: 103171

Parent Item: D4019-041

Parent Item Name: Light Lid Short Basket Assembly

Start Date: 6/18/13

Required Date: 6/19/13

Start Qty: 1.00

Required Qty: 1.00

D4035-047 Manufactured No

100 Each 2.0000

1 1

Lid Rib Assembly, Aft (Light)

PC 13.6.19

Location

Loc Qty

Loc Code

WA005

2

87406

2

①

D4029-043 Manufactured No

180 Each 7.0000

1 1

Webbing (Short Basket)

Location

Loc Qty

Loc Code

ST483

7

56957

4

56967

3

\_\_\_\_\_

D4056-1 Manufactured No

100 Each 21.0000

1 1

Label Plate

PC 13.6.19

Location

Loc Qty

Loc Code

WA004

21

85016

18

87247

3

①

NAS1149DN416J Purchased No

180 Each 1,239.0000

30 30

Washer

Location

Loc Qty

Loc Code

ST293

1239

122151

7

124326

466

124968

166

124983

600

\_\_\_\_\_



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Work Order ID: 103171

Parent Item: D4019-041

Parent Item Name: Light Lid Short Basket Assembly

Start Date: 6/18/13

Required Date: 6/19/13

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

180

Each

1,103.0000

30

30

Cherry Rivets

Location

Loc Qty

Loc Code

ST311

970

122151

4

122452

4

123525

294

124231

668

WA003

133

107939

133

D2728-1

Manufactured

No

180

Each

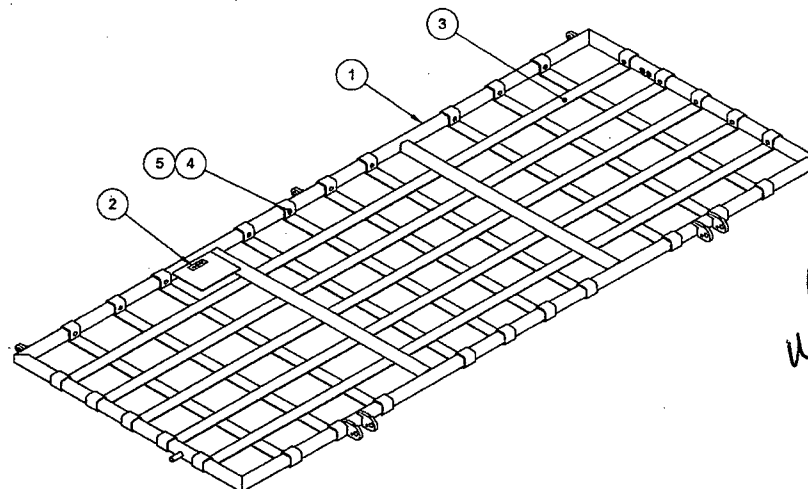
-1.0000

0

0

Dart Logo label small

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4019-041	LIGHT LID SHORT BASKET ASSY
1	1	D4019-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-043	WEBBING (SHORT BASKET)
4	30	MS20600AD4W3	BLIND RIVET
5	30	NAS1149DN416J	WASHER



**D4019-041 LIGHT LID SHORT BASKET ASSY**

W/O 10317H

**RELEASED**  
10.08.05  
ECN 10-596

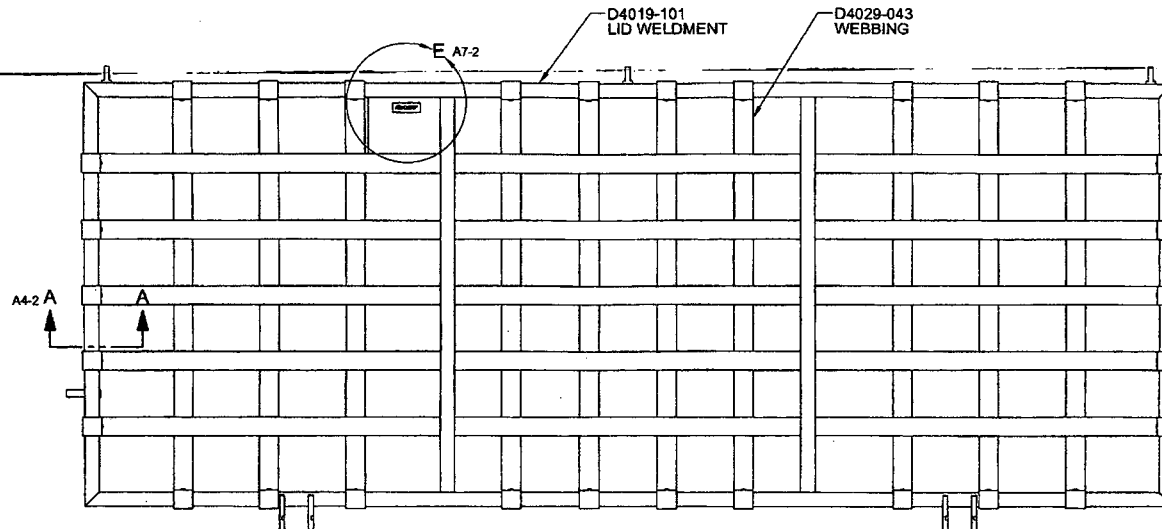
D	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4088-243, UPDATED VIEW E ACCORDINGLY (A7-2); REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
C	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B3-2)	JPH	10.04.06
B	BOM: INSERTED QTY 1 D2728-1 AS ITEM 4 & QTY 1 D4088-243 PLACARD AS ITEM 11. ITEMS RENUMBERED AS REQD. DETAIL E ADDED (A7-2) & (D5-2); SECTION B-8 REV'D (D6-3) DIM ADDED (B4-3); WELD SYMBOL REVISED (D5-3)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.08.05		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

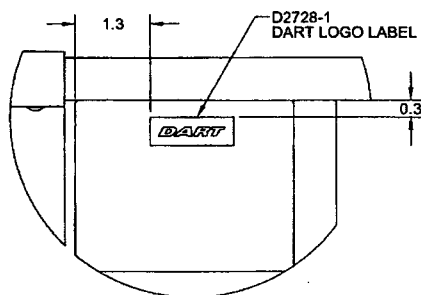
DRAWING NO. **D4019** REV. D  
SHEET 1 OF 4  
TITLE **LIGHT LID SHORT BASKET** SCALE NTS

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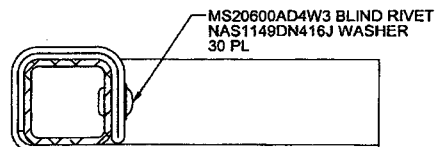
- NOTES:**  
1) MATERIAL: N/A  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: NONE  
7) WEIGHT: 4.83 lbs



**D4019-041 LIGHT LID SHORT BASKET ASSY**



**DETAIL E D5-2**



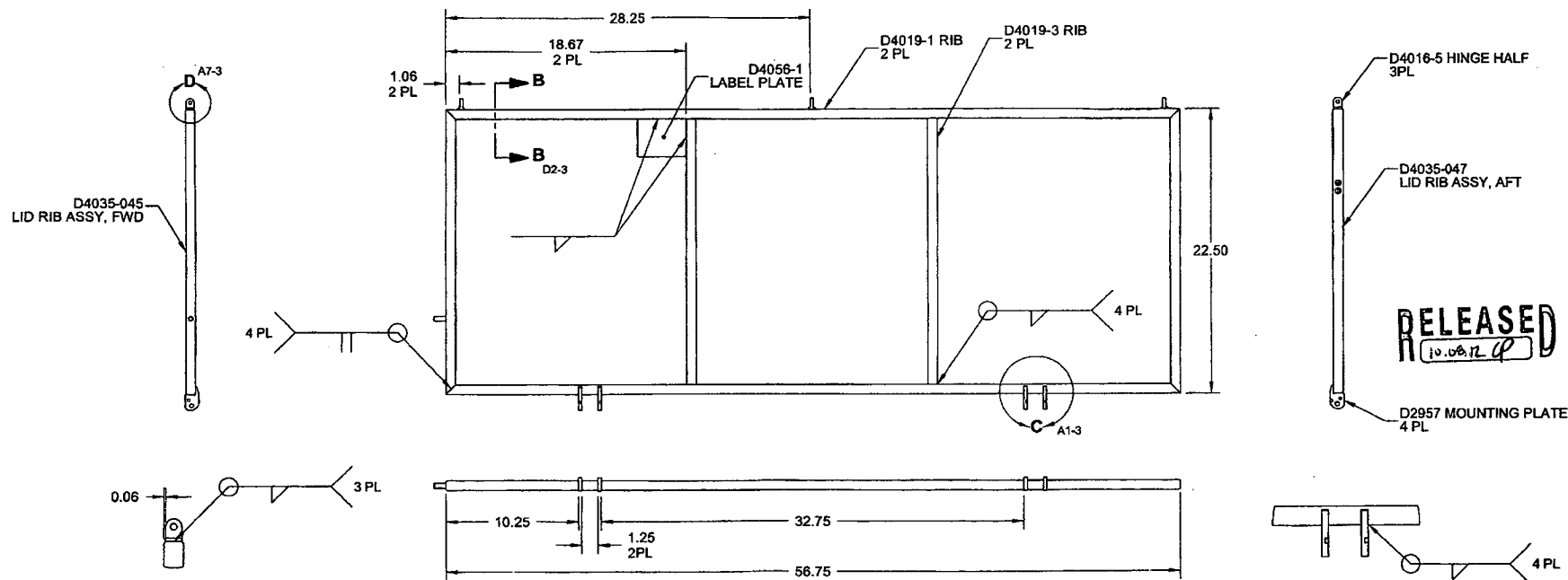
**SECTION A-A C7-2**

**RELEASED**  
10-08-12

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.	MS	D4019	SHEET 2 OF 4
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	LIGHT LID SHORT BASKET	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY	P/N	DESCRIPTION
	X	D4019-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	3	D4016-5	HINGE HALF, LIGHT LID
3	2	D4019-1	RIB
4	2	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET

# SECTION B-B C6-3



DETAIL D C7-3

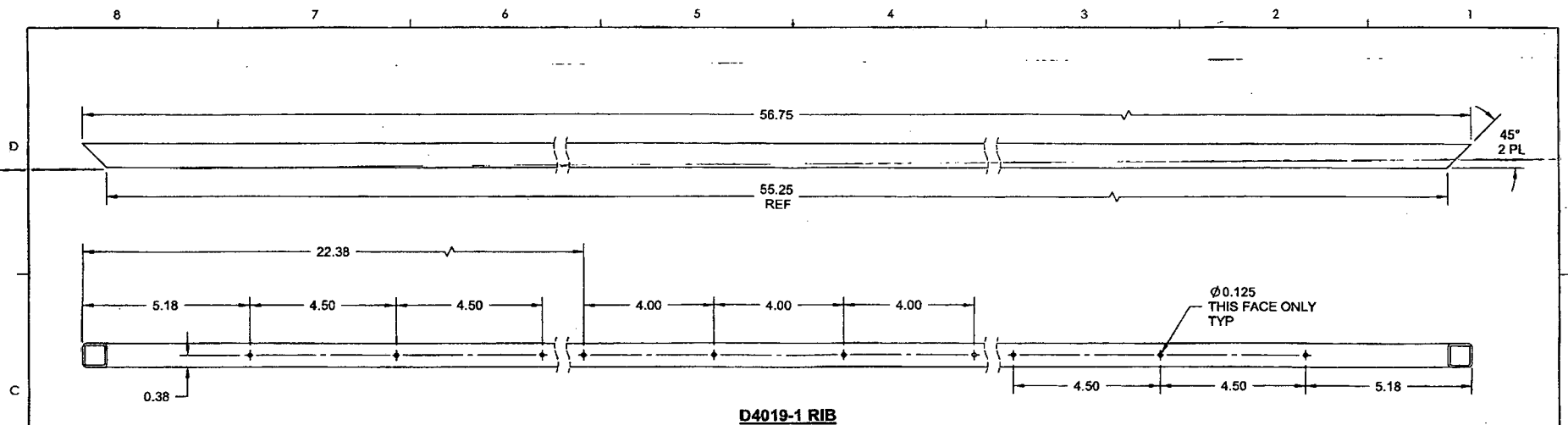
D4019-101 BASKET LID WELDMENT ASSY

DETAIL C B3-3

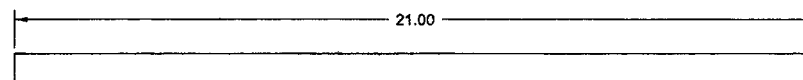
## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.32 lbs
- 8) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MD	DRAWING NO.	REV. D
MFG. APPR.	MD	D4019	SHEET 3 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	LIGHT LID SHORT BASKET	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE RELEASED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D4019-1 RIB**



**D4019-3 RIB**

**RELEASED**  
10.08.12

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING  
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs  
-3: 0.77 lbs

DESIGN	AS	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. <b>D4019</b>	REV. D
MFG. APPR.	AS	SHEET 4 OF 4	
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	<b>LIGHT LID SHORT BASKET</b>	
DATE	10.08.05	NTS	

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